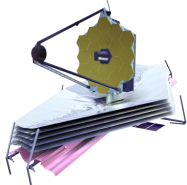




## 50+ years of NASA Mirror Technology Development:

from Hubble to JWST and Beyond



H. Philip Stahl, Ph.D.  
NASA



- WHERE IS THE U.S. GOING IN SPACE ?
- WHAT PROSPECTIVE NATIONAL GOALS REQUIRE NEW SPACE OPTICS ?
- SPACE ASTRONOMY
  - RESOLUTION
  - ULTRAVIOLET SPECTROSCOPY
  - INFRARED SPECTROSCOPY
- PLANETARY PROBES
  - LASER COMMUNICATION



### Presidential Vision

“... both optical and radio astronomy ... new fields of interest have been uncovered – notably in the high energy x-ray and gamma-ray regions. Astronomy is advancing rapidly at present, partly with the aid of observations from space, and a deeper understanding of the nature and structure of the Universe is emerging ... Astronomy has a far greater potential for advancement by the space program than any other branch of physics”.

### SPACE ASTRONOMY NEEDS

- LARGE-APERTURE DIFFRACTION-LIMITED OPTICS
  - 2 METER
  - 3 METER
  - 10 METER
- FINE POINTING SYSTEMS ( $< 1/100$  SEC.)
  - ALL WAVELENGTH TRANSFER LENS
  - PRECISE TORQUER GIMBALS
  - FREE FLOAT TELESCOPES
- SPACE MAINTAINABILITY
  - ALIGNMENT AND TUNE-UP
  - MODULAR SERVICING
  - SCIENTIFIC EXPERIMENTS FLEXIBILITY

Perkin-Elmer 1967



### Presidential Vision

“... both optical and radio astronomy ... new fields of interest have been uncovered – notably in the high energy x-ray and gamma-ray regions. Astronomy is advancing rapidly at present, partly with the aid of observations from space, and a deeper understanding of the nature and structure of the Universe is emerging ... Astronomy has a far greater potential for advancement by the space program than any other branch of physics”.

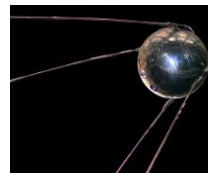
Space Task Group report to the President, September 1969

“A Long-Range Program in Space Astronomy”, position paper of the Astronomy Missions Board, Doyle, Robert O., Ed., Scientific and Technical Information Division Office of Technology Utilization, NASA, July 1969.



### 55 years ago in 1957 Space Astronomy Changed

On Oct 4, 1957 the world changed – Sputnik was placed in orbit around the Earth – and the Space Race was begun.



NASA formally opened for business on Oct. 1, 1958.



## State of Art before Sputnik

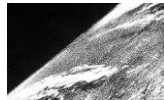
There are two important dates for American Space Astronomy before Sputnik:

10 Oct 1946, the first Ultraviolet Spectrum (to 210 nm) of the sun was obtained via a small film camera spectrograph mounted on a German V-2 Rocket launch by Von Braun's group at White Sands, NM.

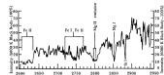
25 Sept 1957, the first launch of Stratoscope I.



US test launch of a Bumper V-2



First Image of Earth from Space



First UV Solar Spectra from Space



## Stratoscope I & II – 1957 to 1971

Stratoscope I (initial 25 Sept 1957)

Conceived by Martin Schwarzschild  
Build by Perkin-Elmer  
30 cm (12 inch) primary mirror  
Film recording

Stratoscope II

Conceived by Martin Schwarzschild  
Build by Perkin-Elmer  
90 cm (36 inch) primary mirror  
Payload 3,800 kg  
25 km altitude  
Film & Electronic



MSFC Launch September 9, 1971



## Space Astronomy

But,

Rocket Missions last for only a few minutes

Balloon Missions operate in the presence of Gravity and have a relatively 'soft' ride.

And neither are truly space.



## The Berkner Telegram

On July 4, 1958, Dr. Lloyd Berkner, Chair of the Space Science Board of the National Academy of Sciences, sent telegrams requesting suggestions for scientific experiments that may be performed by a satellite with a 50 kg capacity & fly in 2 years.

Proposals were due in 1 week. He got 200 responses.

This telegram and its responses lead to the OAO program.

Kick-off meeting was in 1959

Ames defined Requirements

GSFC was lead center

Grumman was Prime.



## Orbiting Astronomical Observatory (OAO)

From 1966 to 1972 NASA launched 4 OAO satellites

All had UV Science Experiments

OAO-I April 1966: Failed due to corona arching.

OAO-II Dec 1968 (on Atlas Centaur) to Jan 1973

OAO-B Nov 1970: Failed, Atlas Centaur didn't achieve orbit

OAO-C Aug 1972 to Feb 1981



OAO-B, B, and C Experiments and Principal Investigators

| Spacecraft | Experiment   | Principal Investigators                           |
|------------|--|---|
| OAO-B      | University of Wisconsin Experiment                             | Dr. A. D. Galt, Dr. T. E. Stock                   |
|            | Smithsonian Astrophysical Observatory Experiment               | Dr. F. Whipple, Dr. R. J. Davies                  |
| OAO-B      | GSFC Experiment  | Dr. A. Bregman, Dr. J. Goldard                    |
| OAO-C      | Princeton University Experiment (Princeton Experiment Package) | Dr. Lyman Spitzer, Dr. John B. Regenstein, Jr.    |
|            | University College, London Experiment                          | Prof. R. F. L. Boyle - University College, London |



## OAO-C (Copernicus)

OAO-C had two Science Experiments

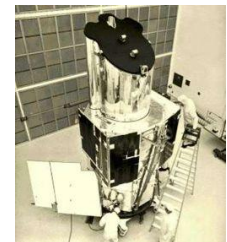
Princeton Experiment Package was a UV Spectrometer

81 cm Cassegrain telescope  
Built by Perkin-Elmer for Princeton  
Fine Guider achieved 0.1 arc-sec pointing

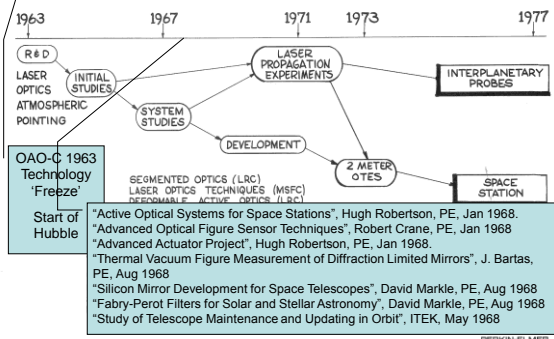
London Experiment X-Ray Package

3 small x-ray telescopes  
5.5 cm<sup>2</sup> for 3 to 9 Angstroms  
12 cm<sup>2</sup> for 6 to 18 Angstroms  
23 cm<sup>2</sup> for > 44 Angstroms

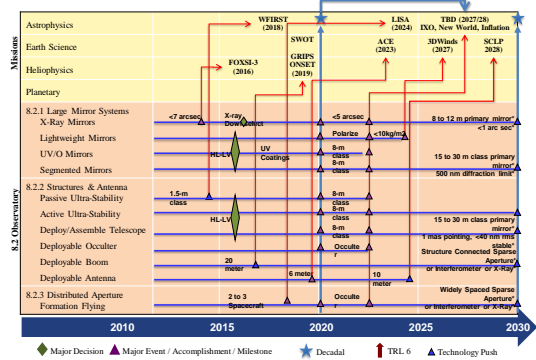
Deep parabolic grazing incidence mirrors  
'first' piggy-back experiment  
'first' x-ray telescopes in space?



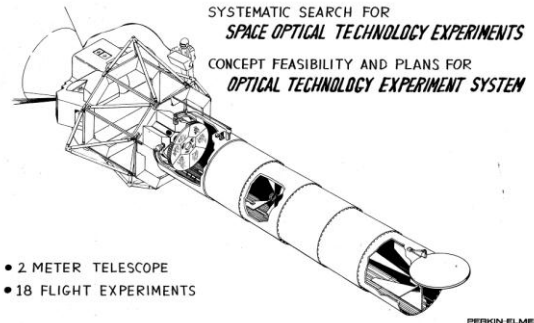
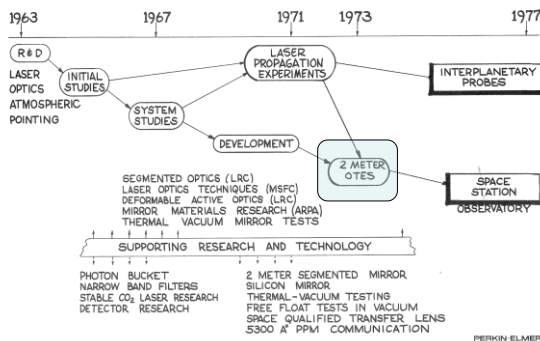
## NASA SPACE OPTICS TECHNOLOGY PLAN



## 8.2 Observatories Roadmap (OCT, 2011)



## NASA SPACE OPTICS TECHNOLOGY PLAN



Optical Technology Experiment System (OTES), PE, 1967  
Large Telescope Experiment Program (LTEP), PE 1969

## 2-METER OTE JUSTIFICATION

PROVIDE NASA WITH DATA FOR NATIONAL SPACE OBSERVATORY

- ORBITAL ALTITUDE DECISION DATA  
DAYLIGHT ASTRONOMY  
POINTING DISTURBANCES  
THERMAL BALANCE
- MANNED SPACE ASTRONOMY TECHNIQUES  
ERECTION  
ALIGNMENT  
MODIFICATION  
MAINTENANCE
- PRIMARY MIRROR EVALUATION  
ACTIVE OPTICS  
SEGMENTED TESTS  
DEFORMABLE TESTS  
THERMAL TESTS
- MATERIALS  
QUARTZ  
SILICON  
CERVIIT  
BERYLLIUM
- POINTING DEVELOPMENT  
TRANSFER LENS  
FREE FLOAT  
FLEXURE GIMBALS  
CLUSTER - AUTONOMOUS MODES

PERKIN ELMER



"Large Telescope Experiment Program (LTEP)", Perkin-Elmer, Aug 1969



## Large Telescope Experiment Program (LTEP)

Funded by the NASA Apollo Application Office

NASA is seriously searching out meaningful goals for after the most successful Saturn-Apollo missions to the lunar surface.

The new science and technologies of space labs and solar observatories are in the immediate future.

Data ... are critical for settling major questions in cosmology:

is the Universe infinite or not."

"Large Telescope Experiment Program (LTEP) Executive Summary", Alan Wissinger, April 1970



## National Astronomical Space Observatory (NASO)

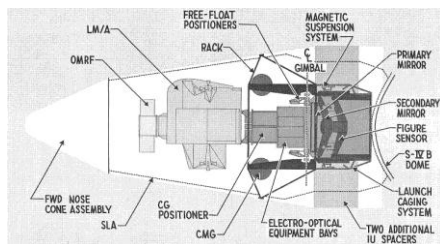
Initial Specifications:

- Operated at permanent space station
- Aperture of 3 to 5 meters
- Spectral Range from 80 nm to 1 micrometer
- Diffraction limit of at least 3 meters (0.006 arc-seconds) at 100 nm.
- Interchangeable experiment packages
- Life time of 10 years
- Field Coverage = 30 arc min
- Pointing Accuracy of 6 milli-arc second
- Thermal control -  $-80^{\circ}\text{C} \pm 5^{\circ}\text{C}$
- Mass (telescope only) = 5500 lb

"Large Telescope Experiment Program (LTEP) Executive Summary", Alan Wissinger, April 1970



## Initial Launch Configuration for Saturn IB

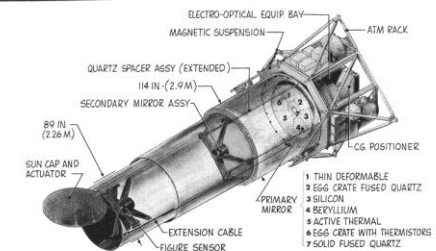


"Large Telescope Experiment Program (LTEP)", Lockheed Missiles and Space Company, Jan 1970

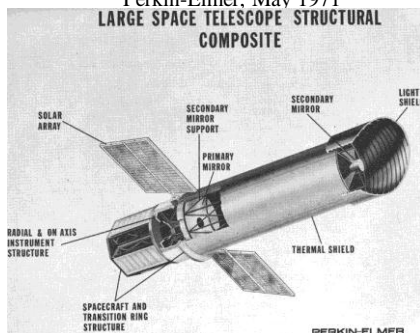


## "Large Telescope Experiment Program (LTEP)", Perkin-Elmer, Aug 1969

### LTEP-2-METER CONCEPT: EXTENDED CONFIGURATION



## "3-meter Configuration Study Final Briefing", Perkin-Elmer, May 1971



## Hubble Deployment April 25 1990











## Mirror Technology Development

A systematic \$40M+ development program was undertaken to build, test and operate in a relevant environment directly traceable prototypes or flight hardware:

- Sub-scale Beryllium Mirror Demonstrator (SBMD)
- NGST Mirror System Demonstrator (NMSD)
- Advanced Mirror System Demonstrator (AMSD)
- JWST Engineering Test Units (EDU)

Goal was to dramatically reduce cost, schedule, mass and risk for large-aperture space optical systems.

A critical element of the program was competition – competition between ideas and vendors resulted in:

- remarkably rapid TRL advance in the state of the art
- significant reductions in the manufacturing cost and schedule

It took 11 years to mature mirror technology from TRL 3 to 6.



## Enabling Technology

It is my personal assessment that there was 4 key Technological Breakthroughs which have enabled JWST:

- O-30 Beryllium (funded by AFRL)
- Incremental Improvements in Deterministic Optical Polishing
- Metrology Tools (funded by MSFC)
  - PhaseCAM Interferometer
  - Absolute Distance Meter
- Advanced Mirror System Demonstrator Project (AMSD)
  - funded by NASA, Air Force and NRO



## Substrate Material



### O-30 Beryllium enabled JWST



Spitzer used I-70 Beryllium while JWST uses O-30 Beryllium.

O-30 Beryllium (developed by Brush-Wellman for Air Force in late 1980's early 1990's) has significant technical advantages over I-70 (per Tom Parsonage)

Because O-30 is a spherical power material:

- It has very uniform CTE distribution which results in a much smaller cryo-distortion and high cryo-stability
- It has a much higher packing density, thereby providing better shape control during HIP'ing which allows for the manufacture of larger blanks that what could be produced for Spitzer with I-70.

Because O-30 has a lower oxide content:

- It provides a surface quality unavailable to Spitzer, both in terms of RMS surface figure and also in scatter.

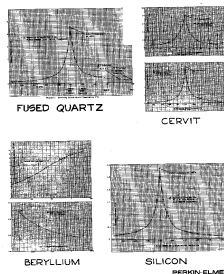
Ability to HIP meter class blanks demonstrated in late 1990's for VLT Secondary.

Full production capability in sufficient quantities for JWST on-line in 1999/2000.

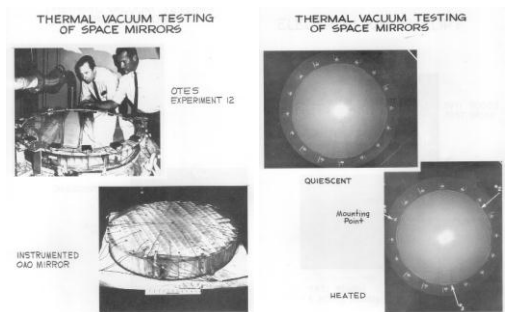


## 1960 Material Property Studies

### PRIMARY MIRROR MATERIALS

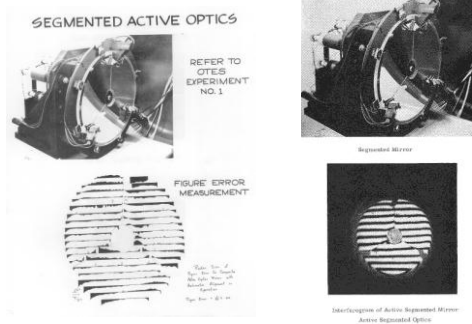


## Thermal Stability was Significant Concern

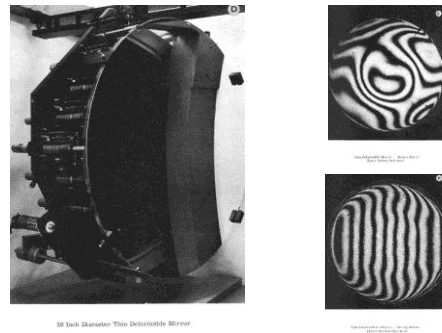




### Solution to Thermal Instability was Segmented Mirror



### Other Solution to Thermal Problem was Active Mirror



### Final Solution was ...

The final solution was to develop better mirror materials:

Cervit,  
ULE,  
Zerodur

which enabled a passive monolithic space telescope mirror



## Mirrors:

### Substrate Technology & Optical Fabrication



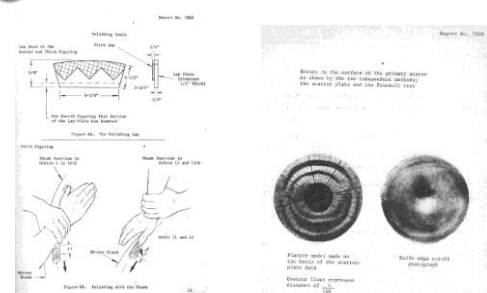
### Stratoscope II – Primary Mirror



36-Inch Diameter Stratoscope II Mirror  
Solid Fused Silica Blank 7940 - Weight 400 Pounds



### Stratoscope II – Optical Fabrication



Classical Fabrication Techniques - Shaped Laps and Hand Figuring

"Test of the Primary and Secondary Mirrors for Stratoscope II", Damant, Perkin-Elmer, Oct 1964.





### OA0-B Primary Mirror

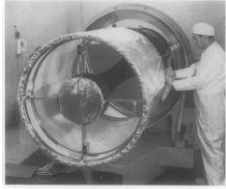


Fig. 3. View of the 58-inch SSP space telescope.

State of Art (6:1 solid blank) fused silica mirror would have had a mass of 310 kg (680 lbs).

Beryllium (S200B) thin meniscus (25:1) substrate with electroless nickel overcoat was fabricated. Its mass was 57 kg (125 lb). Its stiffness minimized gravity sag

"The Goddard Experiment Package - an Automated Space Telescope", Mentz and Jackson, Kollsman Instrument Corp, IEEE Transactions of Aerospace and Electronic Systems, Vol. 5, No. 2, pp. 253, March 1969



### OA0-C Primary Mirror



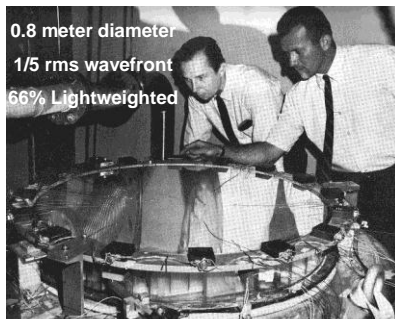
Fig. 4 Primary mirror before coating.

NASA is developing lightweight Egg-Crate Glass Mirror Substrates

"Princeton Experiment Package for OA0-C", Norm Gundersen, Sylvania Electric Products Inc., J Spacecraft, Vol. 5, No. 4, pp. 383, April 1968.



### OA0-C Primary Mirror



32 Inch Diameter OA0-C Princeton University Eggegrate Mirror (Thermal/Deformation Test Instrumentation)



### Hubble Primary Mirror Fabrication 1979-81

GOODRICH



Start of Small Tool Computer Controlled Polishing (I saw this)



### Spitzer (ITTT) PM Fabrication

GOODRICH



### Spitzer PM Fabrication

GOODRICH

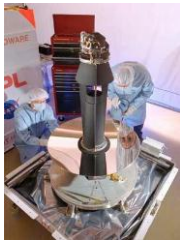


PM used Small Tool Computer Controlled Polishing

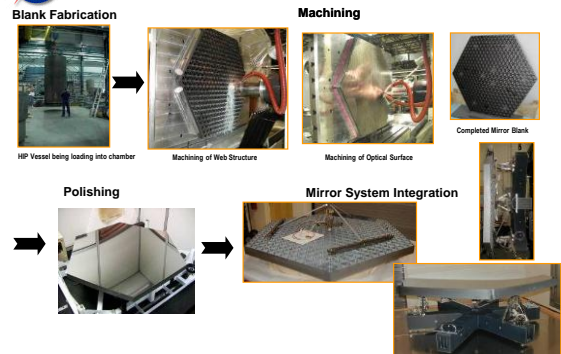
SM used Full Aperture Shaped Laps and Zonal Laps



## Spitzer Optical Telescope Assembly and Primary Mirror



## JWST Mirror Manufacturing Process



## Mirror Fabrication at L-3 SSG-Tinsley



## Optical Testing



### Optical Testing

you cannot make what you cannot measure

In 1999, the NGST program had a problem.

To produce cryogenic mirrors of sufficient surface figure quality, it was necessary to test large-aperture long-radius mirrors at 30K in a cryogenic vacuum chamber with a high spatial resolution interferometer.

The state of the art was temporal shift phase-measuring interferometers, e.g. Zygo GPI and Wyko.

**Spatial resolution was acceptable, but mechanical vibration made temporal phase-modulation impossible.**

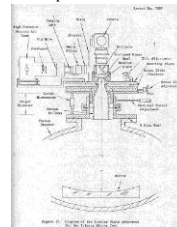
But this problem is nothing new .....



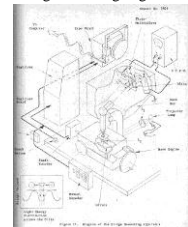
## Stratoscope II – Optical Testing

One solution is common path interferometry

Scatterplate Interferometer



Fringe Scanning Digitizer



(And, in grad school I thought scatterplate interferometer was a laboratory curiosity.)

Testing support from J.M. Burch, A. Offner, J.C. Buccini and J. Houston

OAO-C also used scatter plate interferometry

"Test of the Primary and Secondary Mirrors for Stratoscope II", Damant, Perkin-Elmer, Oct 1964.



## Hubble Testing

Another solution is short exposure time.

Hubble optical testing (at both Perkin-Elmer and Kodak) was performed with custom interferometers taking dozens of film images which were digitized to produce a surface map.

- Camera Shutter Speed 'freezes' vibration/turbulence
- PE used custom micro-densitometer and Kodak manually digitized
- PE tested in the vertical 'Ice-Cream Cone' vacuum chamber

Even in the 1990's when I worked at PE (then Hughes) I would hand digitize meter class prints of interferograms.



## Hubble Primary Mirror Optical Testing

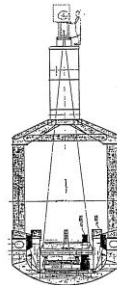
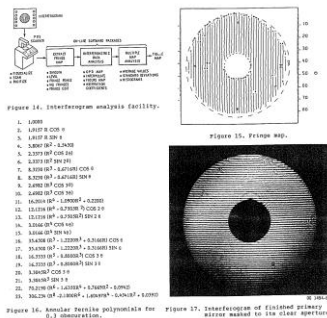


Figure 2. Primary mirror test configuration.

Montagnino, Lucian A., "Test and evaluation of the Hubble Space Telescope 2.4 meter primary mirror", SPIE Vol. 571, pp. 182, 1985.



## Hubble Interferogram Digitization & Analysis

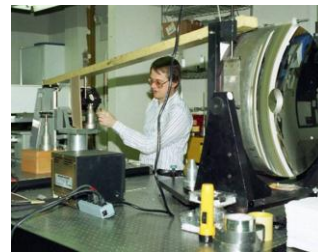


Montagnino, Lucian A., "Test and evaluation of the Hubble Space Telescope 2.4 meter primary mirror", SPIE Vol. 571, pp. 182, 1985.



## Spitzer Secondary Mirror Testing GOODRICH

Another solution is structurally connect interferometer and test.



Spitzer (ITTT) Secondary Mirror Hindle Sphere Test Configuration using a Zygo GPI with Remote PMR Head.



## PhaseCAM

At BRO, I designed, built and wrote the software for a 480 Hz common path phase-measuring Twyman-Green interferometer that was used to test all the Keck segments at ITEK.

As I prepared to leave Danbury for NASA, I was visiting Metrolaser where I saw a breadboard device taking phase-maps of a candle flame.

When I got to NASA I defined the specifications for and ordered the first PhaseCAM interferometer.

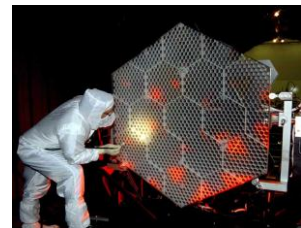
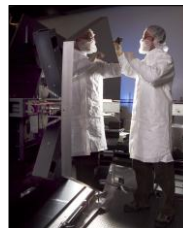
Today they are critical to JWST.



Tech Days 2001



## Mirror Technology Development Program





## Mirror Technology Development

### Systematic Study of Design Parameters

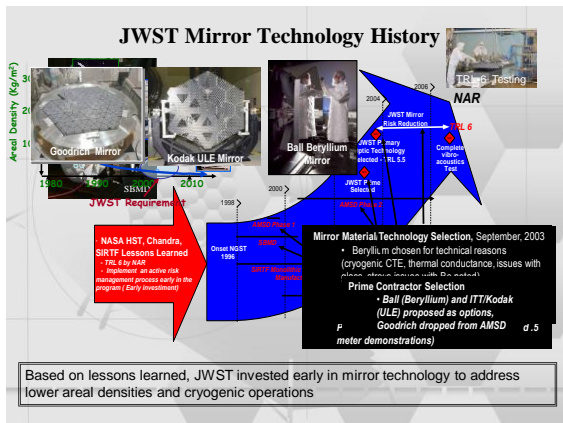
| Item                     | SBMD                    | NMSD                  | AMSD                  |
|--------------------------|-------------------------|-----------------------|-----------------------|
| Form                     | Circle w Flat           | Hex                   | Hex                   |
| Prescription             | Sphere                  | Sphere                | OAP                   |
| Diameter                 | >0.5 m                  | 1.5 - 2 m             | 1.2 - 1.5 m           |
| Areal Density            | < 12+ kg/m <sup>2</sup> | <15 kg/m <sup>2</sup> | <15 kg/m <sup>2</sup> |
| Radius                   | 20 m                    | 15 m                  | 10 m                  |
| PV Figure                | 160 nm                  | 160/63 nm             | 250/100 nm            |
| RMS Figure               |                         |                       | 50/25 nm              |
| PV Mid                   | 63 nm                   | 63/32 nm              |                       |
| (1-10 cm <sup>-1</sup> ) |                         |                       |                       |
| RMS Finish               | 3/2 nm                  | 2/1 nm                | 4/2 nm                |



## Mirror Technology Development

### Wide Variety of Design Solutions were Studied

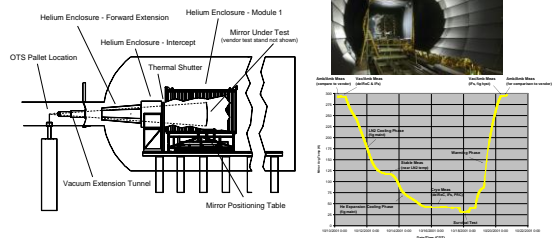
| Item               | SBMD                   | NMSD                              | AMSD  |
|--------------------|------------------------|-----------------------------------|---|
| Substrate Material | Be (Ball)              | Glass (UA)<br>Hybrid (COI)        | Be (Ball)<br>ULE Glass (Kodak)<br>Fused Silica (Goodrich)             |
| Reaction Structure | Be                     | Composite                         | Composite (all)   |
| Control Authority  | Low                    | Low (COI) Low (Ball)<br>High (UA) | Medium (Kodak)<br>High (Goodrich)                                     |
| Mounting           | Linear Flexure         | Bipods (COI)<br>166 Hard (UA)     | 4 Displacement (Ball)<br>16 Force (Kodak)<br>37 Bi/Ax-Flex (Goodrich) |
| Diameter           | 0.53 m                 | 2 m (COI)<br>1.6 m (UA)           | 1.3 m (Goodrich)<br>1.38 m (Ball)<br>1.4 m (Kodak)                    |
| Areal Density      | 9.8+ kg/m <sup>2</sup> | 13 kg/m <sup>2</sup>              | 15 kg/m <sup>2</sup>  |



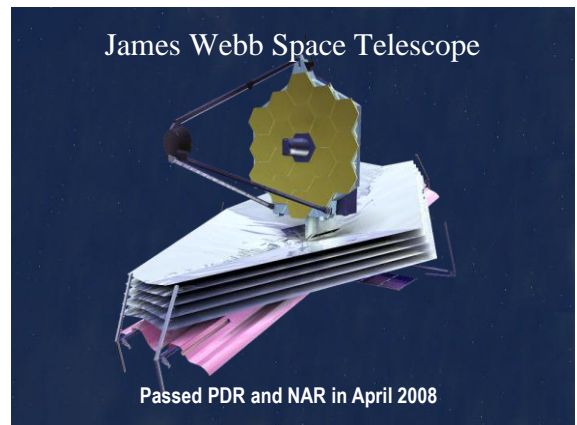
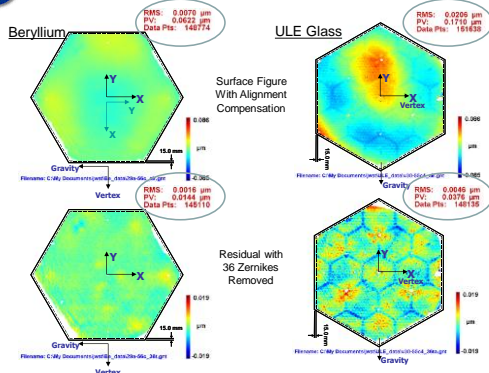
## Performance Characterization

Ambient and Cryogenic Optical Performance was measured at XRCF.

Each mirror tested multiple times below 30K



## AMDS Figure Change: 30-55K Operational Range





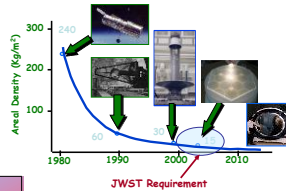
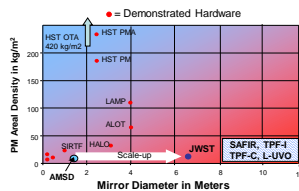


## Mirror Technology Development - 2000

### Challenges for Space Telescopes:

Areal Density to enable up-mass for larger telescopes.

Cost & Schedule Reduction.



| Primary Mirror  | Time                     | Cost                   |
|-----------------|--------------------------|------------------------|
| HST (2.4 m)     | ≈ 1 m <sup>2</sup> /yr   | ≈ \$10M/m <sup>2</sup> |
| Spitzer (0.9 m) | ≈ 0.3 m <sup>2</sup> /yr | ≈ \$10M/m <sup>2</sup> |
| AMSD (1.2 m)    | ≈ 0.7 m <sup>2</sup> /yr | ≈ \$4M/m <sup>2</sup>  |
| JWST (8 m)      | > 6 m <sup>2</sup> /yr   | < \$3M/m <sup>2</sup>  |

Note: Areal Cost in FY00 \$

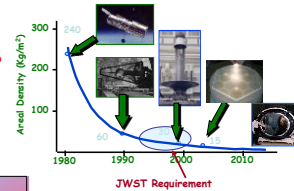
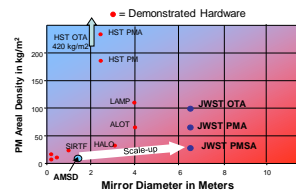


## Mirror Technology Development 2010

### Lessons Learned

Mirror Stiffness (mass) is required to survive launch loads.

Cost & Schedule Improvements are holding but need another 10X reduction for even larger telescopes



| Primary Mirror  | Time                     | Cost                   |
|-----------------|--------------------------|------------------------|
| HST (2.4 m)     | ≈ 1 m <sup>2</sup> /yr   | ≈ \$12M/m <sup>2</sup> |
| Spitzer (0.9 m) | ≈ 0.3 m <sup>2</sup> /yr | ≈ \$12M/m <sup>2</sup> |
| AMSD (1.2 m)    | ≈ 0.7 m <sup>2</sup> /yr | ≈ \$5M/m <sup>2</sup>  |
| JWST (6.5 m)    | ≈ 5 m <sup>2</sup> /yr   | ≈ \$6M/m <sup>2</sup>  |

Note: Areal Cost in FY10 \$



## Chickens, Eggs and the Future

Was Shuttle designed to launch Great Observatories or were Great Observatories designed to be launched by the shuttle?



"Large Telescope Experiment Program (LTEP) Executive Summary", Alan Wissing, April 1970



## Design Synergy

### Shuttle

Payload Bay designed to deploy, retrieve and service spacecraft  
Robotic Arm for capturing and repairing satellites.

### Mission Spacecraft

Spacecraft designed to be approached, retrieved, and repaired  
Generic Shuttle-based carriers to berth and service on-orbit



Chandra and Spitzer were originally intended to be serviceable.

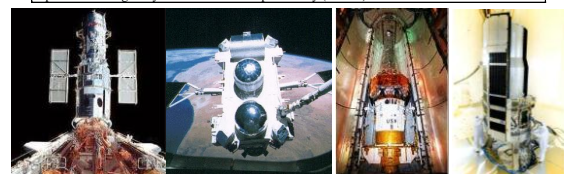


## Great Observatories designed for Shuttle

Hubble, Compton and Chandra were specifically designed to match Space Shuttle's payload volume and mass capacities.

|  | Launch | Payload Mass   | Payload Volume |
|--|--------|--|----------------|
| Space Shuttle Capabilities                         |        | 25,061 kg (max at 185 km)<br>16,000 kg (max at 590 km) | 4.6 m x 18.3 m |
| Hubble Space Telescope                             | 1990   | 11,110 kg (at 590 km)                                  | 4.3 m x 13.2 m |
| Compton Gamma Ray Observatory                      | 1991   | 17,000 kg (at 450 km)                                  |                |
| Chandra X-Ray Telescope (and Inertial Upper Stage) | 2000   | 22,800 kg (at 185 km)                                  | 4.3 m x 17.4 m |

Spitzer was originally Shuttle IR Telescope Facility (SIRTIF)



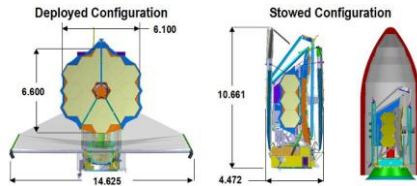




## Launch Vehicles Continue to Drive Design

Similarly, JWST is sized to the Capacities of Ariane 5

|                            | Payload Mass       | Payload Volume   |
|----------------------------|--------------------|------------------|
| Ariane 5                   | 6600 kg (at SE L2) | 4.5 m x 15.5 m   |
| James Webb Space Telescope | 6530 kg (at SE L2) | 4.47 m x 10.66 m |



And now the FUTURE .....

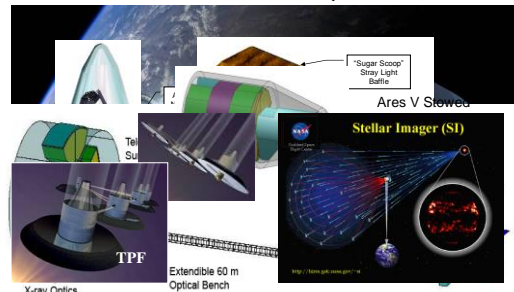
**A Heavy Lift Launch Vehicle  
would be a Disruptive  
Capability which would offers  
the potential for completely new  
Mission Concepts**



## SLS Changes Paradigms

SLS Mass & Volume enable entirely new Mission Architectures:

- 8 meter class Monolithic UV/Visible Observatory



**And now for something  
completely different ....**

**Giant Telescopes  
without mirrors**



## MOIRE 20 meter Diffractive Telescope

### Design Reference Mission Performance Goals

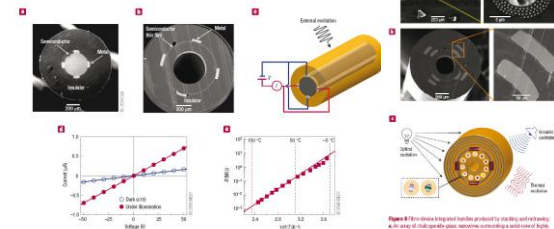
- Persistence – 24/7
- Missile launch detection & vehicle tracking
- Ground Sample Distance – ~ 1m
- Visible/IR Video @ > 1 Hz
- Field of View > 100 sq km
- Field of Regard – 15,000 km by 15,000 km (without slewing)
- < \$500M/copy (after R&D)



Distribution Statement "A" (Approved for Public Release, Distribution Unlimited), DSTAR case 17534 .



## Consider what you could do with Multi-Spectral Fiber Detectors

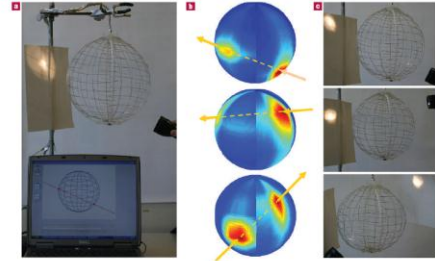


**Figure 1** Multi-spectral fiber detectors. (a) SEM image of a fiber detector. (b) SEM image of a fiber detector. (c) Schematic of a fiber detector. (d) Plot of normalized intensity versus wavelength. (e) Plot of normalized intensity versus wavelength.

Abouraddy, et al., "Towards multimaterial multifunctional fibres that see, hear, sense and communicate", Nature Materials, Vol 6, pp.336, May 2007.



## Computed Axial Tomography Astronomy (Astro-CAT)



**Figure 2** Computed axial tomography astronomy (Astro-CAT). (a) Schematic of the Astro-CAT setup. (b) Photograph of the Astro-CAT setup. (c) Photograph of the Astro-CAT setup. (d) Photograph of the Astro-CAT setup. (e) Photograph of the Astro-CAT setup.

Abouraddy, et al., "Large-scale optical-field measurements with geometric fibre constructs", Nature Materials, Vol 5, pp.532, July 2006.



## Any Question?

